

Work Order ID 86210

86210

Page 1

June-22-12 3:05:36 PM

Item ID: D205-523-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli Rappel, 500lb

Start Date: 22/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/22 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

DSI9301 Rev A

100 0.00

100

DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy blue file & type labels as per PPP D205-523-013, CHG 002

JB *5/26/14* *MLJ 12/07/12*

110 0.00

110

Pick Kit

Packaging Memo 0.00

Packaging

5 *12/07/11 JB*

120 0.00

QC4- 100% Inspect kits for completeness

120

QC Memo 0.00

Quality Control

5/26/14 *(Signature)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and

Packaging

Package as per PPP D205-523-013
StockLocation:

MLC

C 12/07/12 (5)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/07/12
MLJ 12/07/12

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Picklist Print

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Work Order ID: 86210

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Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli Rappel, 500lb

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B02.04.04 Updated Drawing and Added Inspection Level 2ISM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D205-523-043

Manufactured

No

110

Each

1.0000

**

4

85710

D205-523-043

Slide Bar Assembly

Location

Loc Qty

Loc Code

ST187

1

82077

1

D2224

Manufactured

No

110

Each

8.0000

**

45

82093

D2224

Rappel Anchor

Location

Loc Qty

Loc Code

ST489

8

D2229

Manufactured

No

110

Each

18.0000

**

810

D2229

Doubler

Location

Loc Qty

Loc Code

ST006

18

17569

4

33989

4

55316

6

6593

4

2x 17569

4x 55316

4x 6593

JB

12/07/11

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Parent Item Name: Heli Rappel, 500lb

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN5-14A

Purchased

No

110

Each

65.0000

AN5-14A

Bolt

**

16 20 ✓
121259 JB

Location

Loc Qty

Loc Code

ST

8

6071

8

ST338

7

119127

1

120360

6

ST339

50

121259

50

8x 6071

MS21042L5

Purchased

No

110

Each

1,307.000

MS21042L5

Nut

**

12x 121259
16 20 ✓

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

807

108827

4

116105

5

116548

43

117611

14

119109

725

17651

8

2937

8

119109

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

16.0000

AN960JD516

Washer

**

32 40 ✓
119546 JB

Location

Loc Qty

Loc Code

ST338

16

2612

16

June-22-12 3:05:40 PM

Shop Packet Print

Page 2

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66210 MS
12/06/22

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>D. Shepherd</i>	D. SHEPHERD (DE # 02)
DATE: <u>05.05.11</u>	
CERT. NO.: <u>SH96-90</u>	
ISSUE NO.: <u>3</u>	

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Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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25.4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

25.5 PARTS LIST

-013	-023	-043	Part No.	Description
X			D205-523-013	HELI-RAPPEL™ INSTALLATION
	X		D205-523-023	300 HOUR INSPECTION KIT
1		X	D205-523-043	SLIDE BAR ASSEMBLY
		1	D3011-1	RAPPEL SLIDE BAR
		2	33116	STUD FITTING
	2	2	MS21042L6	NUT (OR MS21042-6)
	2	2	AN960JD616	WASHER
	2	2	D3012-1	DECAL
	2	2	D3012-3	DECAL
	2	2	D3012-5	DECAL
1			D2224	RAPPEL ANCHOR
2			D2229	DOUBLER
4	4		AN5-14A	BOLT
8	8		AN960JD516	WASHER
4	4		MS21042L5	NUT (OR MS21042-5)

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